

shp April 23

Work Order ID 82732

82732

Page 1

April-05-12 12:56:19 PM

Item ID: D3326-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Basket Base Assembly

Stop *NS2*

Start Date: 05/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/04/05* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3326

Rev B

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut tubes as per Dwg D3326

2-Remove all markings from material and deburr as required check for foreign objects.

3-Drill and Weld as per Dwg D3324 & QSI 004
A/RN/ASteel Rod *4118875*

4-Deburr as required

110

QC9- Inspct visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

12.04.17 (1x)

1x / PL 12.04.18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.00

Scrub

IX

M-L 12/04/18

Quality Control

130 White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 0.00

130

Powdercoat

Powder Coating

Memo

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

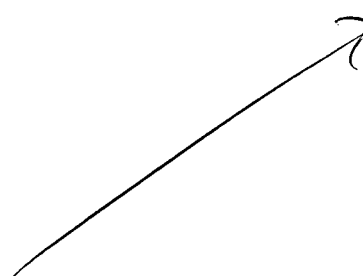
START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:00 400°F
12:30
12:45 400°F
1:15

M 12/134



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Required Date: 20/04/2012 Req'd Qty: 1.00

1

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

1 ϕ ϕ 12-4-18.

150

Identify as per dwg & Stock Location

0.00

150

Packaging

Memo

0.00

Packaging

G.A.
w/o
82730(1x) ϕ ϕ 12/04/19

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 12/04/19

MK

12-04-19

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Picklist Print

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Page 1

Work Order ID: 82732

82732

Parent Item: D3326-041

D3326-041

Parent Item Name: Basket Base Assembly

Start Date: 05/04/2012

Required Date: 20/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.02.09New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NTS0.500W.035		Purchased	No			100	f	311.2976	30.75	32.36842			

M4130NTS0 500W 035

4130 Square tube .500 x .500 x .035w

**

24/12.04.11

Location	Loc Qty	Loc Code
MAT034	311.2976	
109127	87.4767	
109385	15.75	
112786	17.6261	
119441	8.8248	
119506	36.34	
119683	145.28	

32.68+1 END MAT SCRAP

M569EX0.50-18F

Purchased

No

100 sf

114.0000

28

28

M569FX0 50-18F

569 Expanded Metal

**

Pl 12.04.11

Location	Loc Qty	Loc Code
MAT018	64	
120204	64	
MAT019	50	
112776	10	
117806	4	
119226	4	
119404	32	

28

D3328-3

Manufactured

No

100 Each

12.0000

2

2

D3328-3

Basket Hinge

**

24/12.04.11

Location	Loc Qty	Loc Code
WA005	12	
33872	12	

2x

W/O:		WORK ORDER CHANGES					
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Work Order ID: 82732

Parent Item: D3326-041

Parent Item Name: Basket Base Assembly

82732

D3326-041

Start Date: 05/04/2012

Required Date: 20/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3348-1 Manufactured No

100 Each 40.0000 4 4

D3348-1

Clevis

**

12.04.16

Location

Loc Qty

Loc Code

WA005

40

74727

37

75575

3

1x
3x
2

D3349-3 Manufactured No

100 Each 18.0000 2 2

D3349-3

Spacer Bushing

**

12.04.16

Location

Loc Qty

Loc Code

WA005

18

75620

18

2x
2

D3367-1 Manufactured No

100 Each 13.0000 2 2

D3367-1

Mounting Bracket

**

12.04.16

Location

Loc Qty

Loc Code

WA005

13

76500

13

2x

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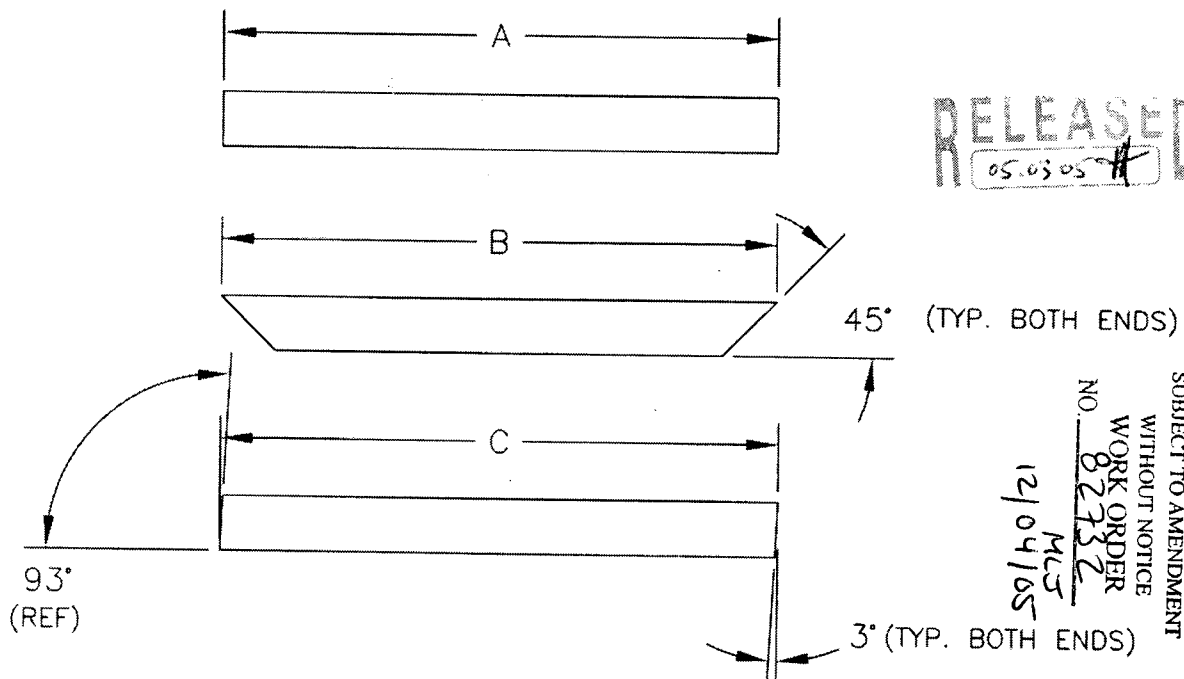
NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3326	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY SCALE NTS	
A	04.10.21	NEW ISSUE	
B	05.03.04	UPDATE TUBING AND MESH MAT'L SPEC	

PARTS LIST FOR D3326-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3326-1	1	14.00	N/A	N/A	BOTTOM TUBE
D3326-3	4	N/A	56.50	N/A	FULL LENGTH TUBE
D3326-5	2	N/A	16.00	N/A	TOP END TUBE
D3326-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3326-9	6	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET



RELEASED
05.03.05

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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82732
12/04/05
MCS

D3326-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL
(REF. DART SPEC M4130-TS0.500W.035)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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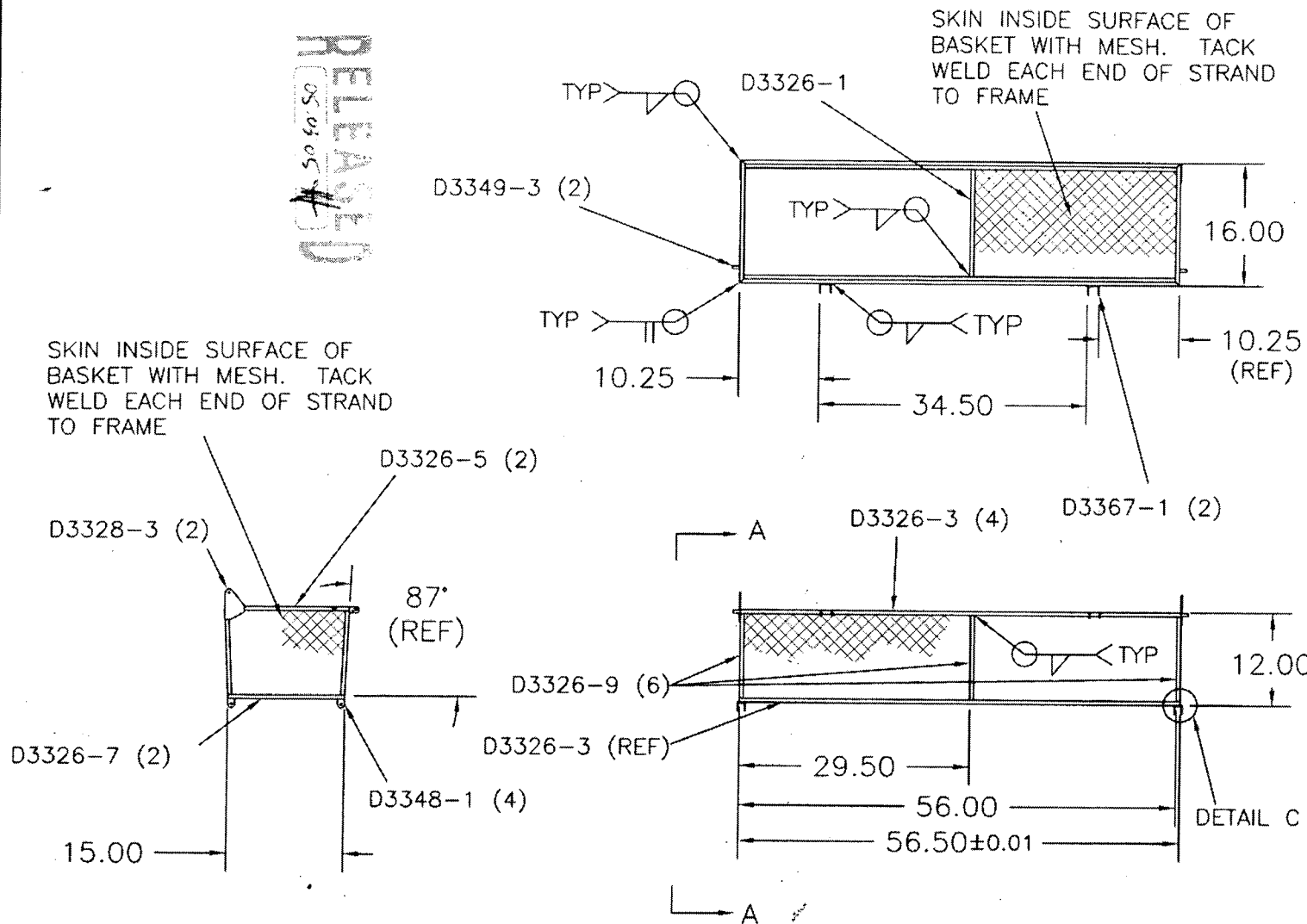
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02732

DART**D3326-041 BASKET BASE ASSEMBLY**

- 1) MESH MATERIAL: 1/2" - 18 GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0

DESIGN	DRAWN BY	DART AEROSPACE LTD
44	44	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
44	44	D3326
DATE	TITLE	REV. B
05.03.04	BASKET BASE ASSEMBLY	SHEET 2 OF 3
		SCALE 1:25

RELEASED
05.03.05

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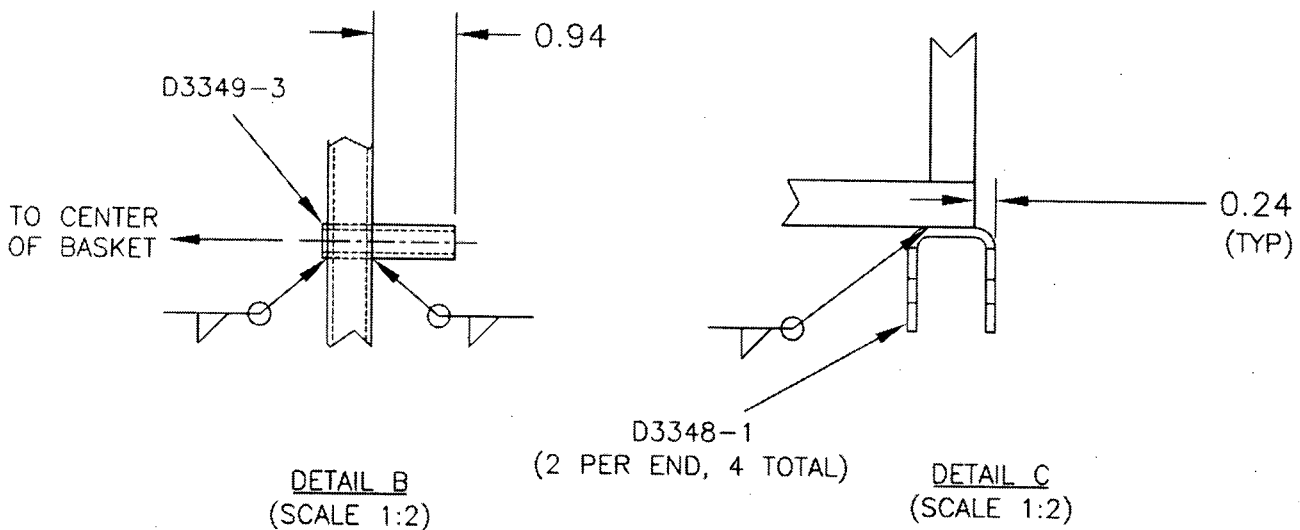
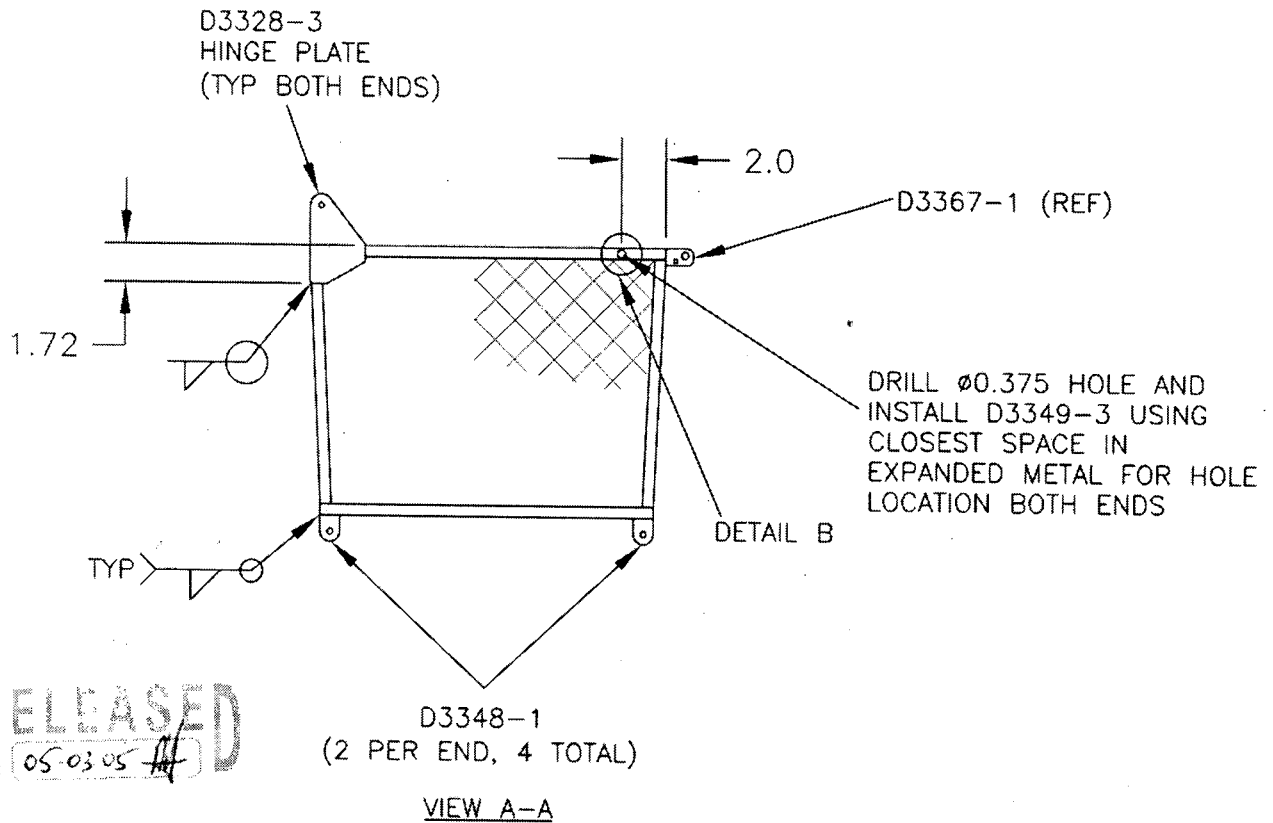
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DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8



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